

Work Order ID 124356

124356

September-11-14 12:03:18 PM

Page 1

Item ID: D4879-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B AFT Leg Assembly, RH
 Start Date: 9/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 11-09-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4879	C ✓								

110 0.00 ***110*** 2 FF MAR 3 1 2015

Small Fab Memo 0.00
 Small Fab ALIGN PILOT HOLES IN D4879-1 WITH PILOT HOLES IN D4885-2 AND
 D4885-7. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
 DWG.
 REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
 DT9969 AS PER DWG.

120 QC5- Inspect part completeness to step on W/O 0.00 ***120*** (2) DAS
 QC Memo 0.00 38
 Quality Control 9-89

MAR 3 1 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
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Training									
Transport									
Unapproved									

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Work Order ID 124356

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124356

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Item ID: D4879-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B AFT Leg Assembly, RH
 Start Date: 9/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: st 230	0.00							
180									
Packaging	Memo	0.00							
Packaging									

2X 2015-04-20

(2)

DAG
38
9-89

APR 21 2015

2 DAG
27
9-89

APR 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Design									
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Handling/Pre									
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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Work Order ID 124356***124356***

Page 4

Item ID: D4879-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: 206A/B AFT Leg Assembly, RH

Stop ***NS2***

Start Date: 9/10/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

15/4/22
AS-4-21

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Picklist Print

September-11-14 12:03:17 PM

Page 1
2

Work Order ID: 124356

124356

Parent Item: D4879-042

D4879-042

Parent Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.12.16 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12		Purchased	No				Each	464.0000		8			
HI 32PB5-12									**				
Hi-Lok Pin													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST263				464					
				M129912				464		8			
D4879-1		Manufactured	No				Each	0.0000		2			
D4879-1									**				
Strut										2			
D4885-2		Manufactured	No				Each	1.0000		2			
D4885-2									**				
End Fitting													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST126				1		2			
				116572				1					
D4885-7		Manufactured	No				Each	2.0000		2			
D4885-7									**				
End Fitting													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST139A				2					
				112036				2		2			

FF MAR 3 1 2015

FF MAR 3 1 2015

FF MAR 3 1 2015

FF MAR 3 1 2015

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

September-11-14 12:03:17 PM

Page 2

Work Order ID: 124356

124356

Parent Item: D4879-042

D4879-042

Parent Item Name: 206A/B AFT Leg Assembly, RH

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 2.00

Required Qty: 2.00

HL86-5

Purchased

No

Each

1,165.000

8

HI 86-5

FF

MAR 31 2015

Collar

Location

Loc Qty

Loc Code

ST263

1165

M128110

12

M128228

29

M129022

200

M129864

924

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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PAGE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28085**

Purchase Order Date 4/13/2015

PO Print Date 4/13/2015

Page Number 2 of 3

Order From :
P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

VC-PL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Total: \$8.00

4	129703	D4868-041 LEG ASSEMBLY	4/20/2015	3.00	\$4.00	\$12.00
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Yes

4/20/2015

LASER MARKED

Line Total: \$12.00

5	124356	D4879-042 AFT LEG ASSEMBLY	4/20/2015	2.00	\$4.00	\$8.00
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Yes

4/20/2015

LASER MARKED

4815-04-20

Line Total: \$8.00

6	71401-45	PROCUREMENT QUALITY CLAUSES	4/20/2015	1.00	\$0.00	\$0.00
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No

4/20/2015

Quality Procurement Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A042 DART NOTIFICATION BY SUPPLIER

Note:

4/13/2015



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE April 16, 2015

P.O NUMBER PO28085

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4801-041 LEG ASSEMBLY	6	ALL ITEMS HAVE BEEN LASER MARKED
D4837-041 LEG ASSEMBLY	4	
D4866-041 LEG ASSEMBLY	2	
D4868-041 LEG ASSEMBLY	3	
D4979-042 LEG ASSEMBLY	2	

OP B 04-20



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7706

Date: April 16, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
28085		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4801-041	6.00	4.00	✓	24.00
Laser Metal Marking, D4837-041	4.00	4.00	✓	16.00
Laser Metal Marking, D4866-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4866-041	3.00	4.00	✓	12.00
Laser Metal Marking, D4879-042	2.00	4.00	✓	8.00
SP15-04-20				
Sub-Total				\$68.00
13.00% on 68.00				8.84
Total				\$76.84

Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You